

Date: Thursday, 2/22/2007 2:58:15 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR WEDGE
Job Number	: 30826		
Estimate Number	: 12111		
P.O. Number	: <i>N/A</i>	Part Number	: D32003
This Issue	: 2/22/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3200 REV A
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 28107	Material	: <i>N/A</i>
Written By	:	Due Date	: 3/10/2007
Checked & Approved By	: <i>[Signature]</i> 07.02.23	Qty:	20 Um: Each
Comment	: Est Rev: <i>A</i> Removed from 9 Digit 06-01-25 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.0158 sf(s)/Unit Total : 0.3150 sf(s)  
 UHMW 1" Black  
 Material: Black UHMW 0.95" or 1.00" thick  
 Use bearpaw scrap material  
 (MUHMWB10)  
 Identify for D3200-1  
 Batch: *M 101627*

*ml 07/03/03* 25

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blank: 1.000 X 1.800"

*ml 07/03/03* 25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine D3200-3 as per Folio FA337 and Dwg D3200  
 2-Deburr

*ml 07/03/03* 25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07/03/03* 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR WEDGE

Job Number: 30826

Part Number: D32003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 07/03/04 25

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten signature and date: 07/03/05 (25) U*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*Handwritten circled number: 25*

Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten signature and date: 07/03/06*

Job Completion



*Handwritten signature and date: 07/03/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

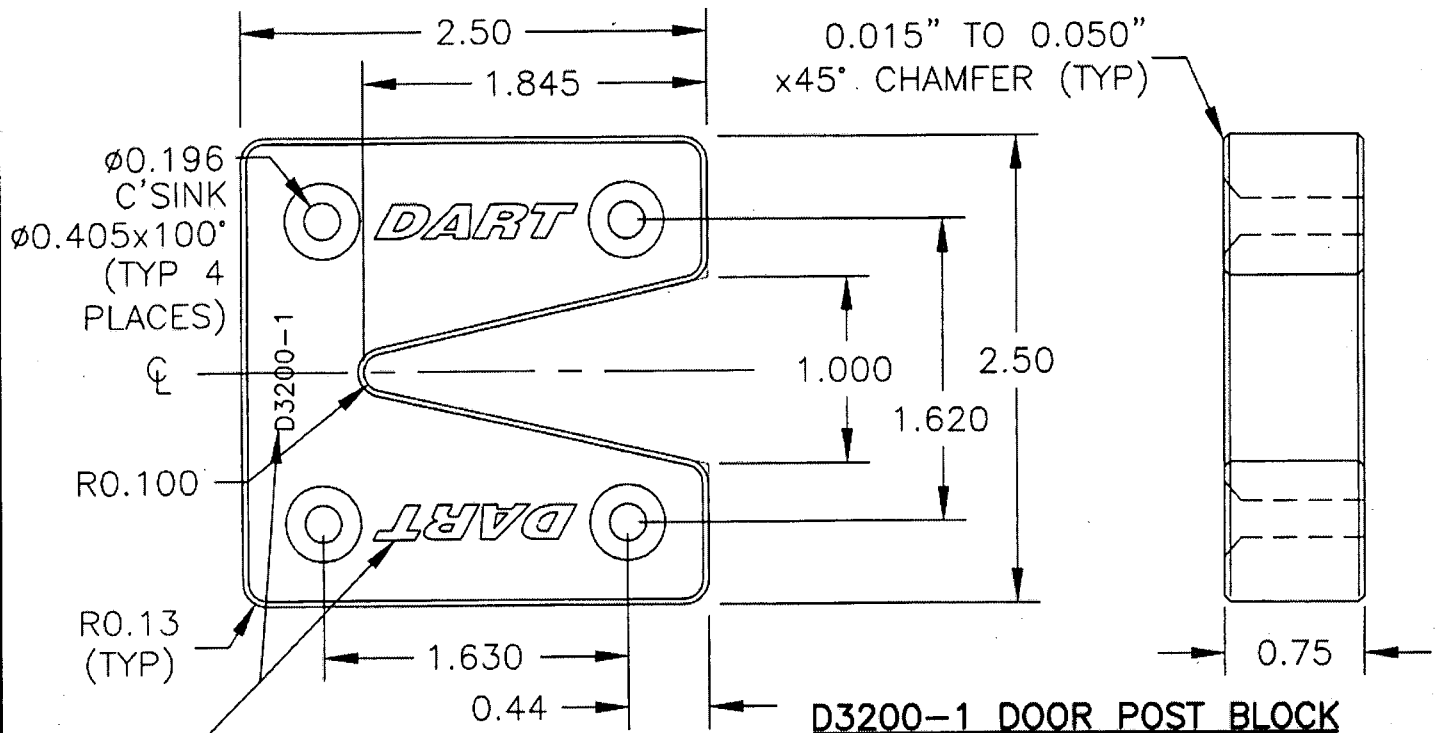
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

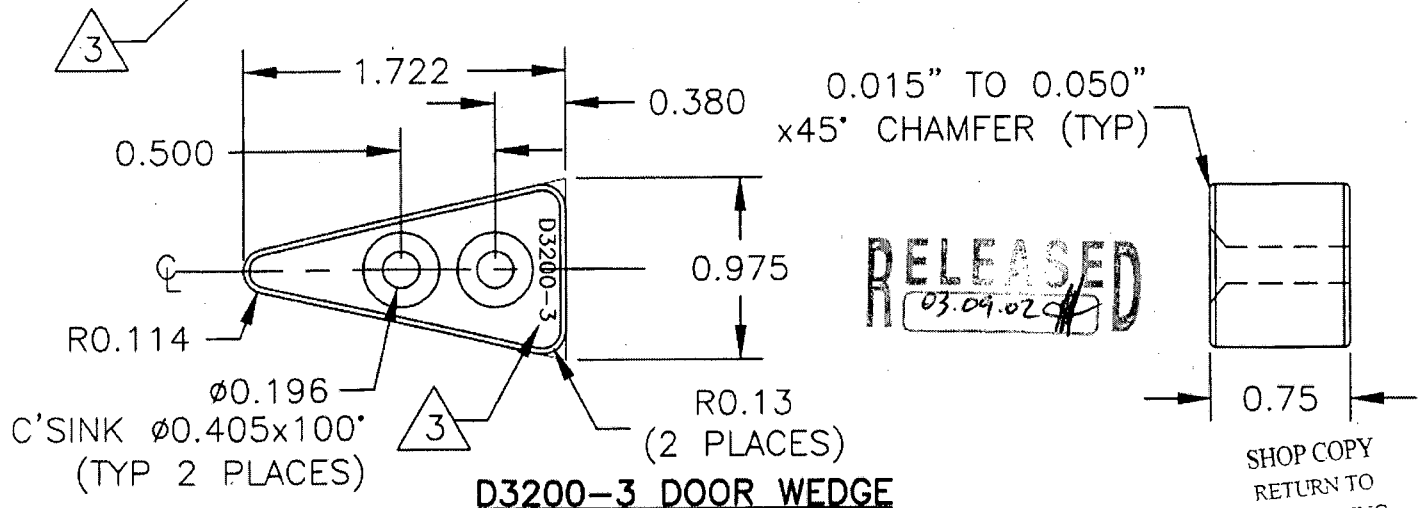




DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06		TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06	NEW ISSUE	



**D3200-1 DOOR POST BLOCK**



**D3200-3 DOOR WEDGE**

**D3200-1/-3**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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03.09.02

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WORK ORDER  
NO. 30826